



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4030-041
Job Sheet 172569



Part No: D4030-041

Job Qty: 1 ea

Part Name: Long Basket Assembly (350)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/20/18

Job Tracking No:

Due Date: 2/22/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV D SHEETS 1,3,4 IPP Rev:A new issue DD 10.03.23 verified by:EC IPP Rev:B as per dwg revB DD 10.04.20 verified by:EC IPP Rev:C as per dwg revC DD 10.08.18 verified by:EC IPP Rev D 12.03.27 per NCR12-1239 EC verified by:JLM

Ship Via:

001128

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		2/21/18	0.00	0.00	Start Up Stores/Pkg-1		JSR 18-2-22
100	Packaging	1 pcs		2/21/18	0.00	0.00	Packaging1-4		JSR 18-2-22
110	HandFinish	1 pcs		2/22/18	0.00	1.03	HandFinish4		JSR 18-2-27
120	QC	1 pcs		2/22/18	0.00	0.00	QC5		JSR
130	Packaging	1 pcs		2/22/18	0.00	0.00	Packaging3-2		
140	QC21-SA	1 Ea		2/22/18	0.00	0.00	QC21		

DAS
21
9-59

FEB 23 2018



Container No: S044735



Part: D4030-041

Job No: 172569

Serial No/Batch: S044735

Revision: D4030

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 02/22/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-14A	Bolt	4 Ea (4 ea)	90-Start up Operation	5014387
AN3-16A	Bolt	2 Ea (2 ea)	90-Start up Operation	5014737
AN310-4	Nut	3 Ea (3 ea)	90-Start up Operation	5019389
AN310C4	Nut	2 Ea (2 ea)	90-Start up Operation	5019390
AN4-12	Bolt	3 Ea (3 ea)	90-Start up Operation	5015684
AN5-17A	Bolt	4 Ea (4 ea)	90-Start up Operation	5019409
D2530	Handle Weldment	1 Ea (1 ea)	90-Start up Operation	5040009
D2535	Spring	2 Ea (2 ea)	90-Start up Operation	5014109
D2537	Bushing	2 Ea (2 ea)	90-Start up Operation	5034734
D3917-3	Washer 503632X(xd)	6 Ea (6 ea)	90-Start up Operation	5024117
D3953-17	Gas Spring Spacer	2 Ea (2 ea)	90-Start up Operation	5043082
D3953-19	Gas Spring Bracket	1 Ea (1 ea)	90-Start up Operation	5020996
D3953-21	Gas Spring Bracket	1 Ea (1 ea)	90-Start up Operation	5033740
D3953-3	Gas Spring Stud, Lid	2 Ea (2 ea)	90-Start up Operation	5014257
D3953-7	Spring Spacer	2 Ea (2 ea)	90-Start up Operation	5036671
D3953-9	Gas Spring Washer	2 Ea (2 ea)	90-Start up Operation	5036726
D3969-3	Spring (Basket Lid)	1 Ea (1 ea)	90-Start up Operation	5038779
MS21042L3	Nut	6 Ea (6 ea)	90-Start up Operation	50372841
MS21042L5	Nut	4 Ea (4 ea)	90-Start up Operation	5016830
MS24665-151	Cotter Pin	3 Ea (3 ea)	90-Start up Operation	FM128401
MS24665-300	Cotter Pin	2 Ea (2 ea)	90-Start up Operation	5015687
NAS1149C0432R	Washer	2 Ea (2 ea)	90-Start up Operation	5025747
NAS1149F0332P	Washer	8 Ea (8 ea)	90-Start up Operation	5020603
NAS1149F0432P	Washer	6 Ea (6 ea)	90-Start up Operation	5034412
NAS1149F0563P	Washer	4 Ea (4 ea)	90-Start up Operation	5038769
D3913-041	Long Basket Base Assembly, 350	1 Ea (1 ea)	110-HandFinish	5041888
D3914-041	Long Basket Lid Assembly (350)	1 Ea (1 ea)	110-HandFinish	50412391

000128

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-14A	4	184	0
	AN3-16A	2	54	0
	AN310-4	3	89	0
	AN310C4	2	87	0
	AN4-12	3	123	0
	AN5-17A	4	115	0
	D2530	1	14	0
	D2535	2	22	0
	D2537	2	72	0
	D3917-3	6	127	0
	D3953-17	2	55	0
	D3953-19	1	36	0
	D3953-21	1	9	0
	D3953-3	2	51	0
	D3953-7	2	30	0
	D3953-9	2	33	0
	D3969-3	1	16	0
	MS21042L3	6	3,517	0
	MS21042L5	4	961	0
	MS24665-151	3	135	0
	MS24665-300	2	64	0
	NAS1149C0432R	2	1,361	0
	NAS1149F0332P	8	3,555	0
	NAS1149F0432P	6	1,448	0
	NAS1149F0563P	4	205	0
110-HandFinish	D3913-041	1	5	0
	D3914-041	1	7	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					